

Work Order ID 91959

October-19-12 2:49:32 PM

91959

Page 1

Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12-10-22 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3272	Rev B								
-------	-------	--	--	--	--	--	--	--	--

100									
-----	--	--	--	--	--	--	--	--	--

100	DOCUMENT CONTROL								
-------	------------------	--	--	--	--	--	--	--	--

DC	Memo								
----	------	--	--	--	--	--	--	--	--

Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
------------------	---	--	--	--	--	--	--	--	--

0.00 54 0AS 15 12.11.21

10 12.11.21

10

110									
-----	--	--	--	--	--	--	--	--	--

110	Large Fab								
-------	-----------	--	--	--	--	--	--	--	--

Large Fab	Memo								
-----------	------	--	--	--	--	--	--	--	--

Large Fab	1-Bevel end for welding FWD ONLY								
-----------	----------------------------------	--	--	--	--	--	--	--	--

0.00

0.00

10 12.11.21

12.11.21

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod 122358

122431

3-Grind End Plate flush 122399

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

15

12-11-12

DAS
09
8-89

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

15
8-89

10

140

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10

26

12-11-12

Hand Finishing

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Item ID: D350-591-312

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150*	QC-Inspect Part Finish	0.00				10	0		D4S 23 89

QC
Quality Control

180 *180*	Large Fab	0.00	10	0	<i>Ac 12.11.15</i>
Large Fab	Memo	0.00			<i>12.11.15</i>
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.				<i>Ac 12.11.15</i>
	2-Leave one rivet out until welding is complete.				
	3-Bevel Aft end for welding				
	4-Inspect for foreign object as per QSI 024				
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod <u>122358</u>				
	6-Grind End Plate flush				
	7-Install last rivet as per Dwg.				

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Item ID: D350-591-312

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

(10) 12-11-16

DAS
09
8-89

190

QC

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

(10) 12-11-16

DAS
09
8-89

200

QC

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

10X/

MF
12/11/16

210

HandFinish

Hand Finishing

Memo

0.00

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91959

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Item ID: D350-591-312

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

3-40

0.00

START TIME:

320 0F

OVEN TEMPERATURE:

FINISH TIME: 4-10

10 X ✓

ML
12/11/19

R1T

230

Wing Walk as per dwg QSI005 4.4 Batch 122588

0.00

230

HandFinish

Hand Finishing

Memo

0.00

Dkt Bl 12/11/20

240

QC3- Inspect Part Finish

0.00

AS

15

9-89

0.00

10/11-20

10

240

QC

Quality Control

Memo

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91959

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Item ID: D350-591-312

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

250

Packaging

Packaging

Pick Kit

0.00

16x

SP

12/1/20

260

260

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

DAS
15
8-89
10/10/12

10

270

270

Packaging

Packaging

Packaging

0.00

Memo
Identify and pack for shipping as per PPPD350-591-312
Location: HALL RAOB

0.00

12/1/22

DAS
20
89
SL

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop

NS2

Start Date: 10/19/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/11/22
MF
12-11-22

Picklist Print

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Page 1

Work Order ID: 91959

Parent Item: D350-591-312

Start Date: 10/19/12

Required Date: 11/09/12

Parent Item Name: Heli-Access-Step, Long RH

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

IPP Rev:D fixe route seq in bom DD

10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 Step		Manufactured	No			110	Each	20.0000	1	10		Ac 12.10.31	
					<u>Location</u>		<u>Loc Qty</u>						
					ST			-10					
					WA	B92140	→	30					10X
								86573					
								91756					
								91757					
D3067-1 End Plate		Manufactured	No			110	Each	226.0000	1	10		Ac 12.10.08	
					<u>Location</u>		<u>Loc Qty</u>						
					WA			222					
						78608		4					
						83855		1					
						90177		15					
						90178		22					
						90335		60					10
						90336		60					
						90486		60					
					WA016			4					
						67582		2					
						68214		1					
						79607		1					

Picklist Print

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Page 2

Work Order ID: 91959

Parent Item: D350-591-312

Start Date: 10/19/12

Required Date: 11/09/12

Parent Item Name: Heli-Access-Step, Long RH

Start Qty: 10.00

Required Qty: 10.00

D3219-1
Plate

Manufactured

No

110

Each

274.0000

2

20

Ac 12.11.08

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	256	
88888	12	
89966	108	
<u>89967</u>	108	
90704	28	

WA016	18	
73410	12	
77674	6	

D3066-1
Spacer

Manufactured

No

180

Each

179.0000

2

20

Ac 12.11.15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	179	
90211	30	
<u>90212</u>	60	
<u>90346</u>	29	
90347	60	

MS20600-AD4W4
Rivets

Purchased

No

180

Each

1,578.0000

16

160

Ac 12.11.15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

321	18	
121652	18	
ST311	1000	
<u>123021</u>	1000	
ST321	560	
121011	9	
121340	39	
121444	512	

Picklist Print

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Page 3

Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured

No

180

Each

21.0000

1

10

Step Leg Assembly Hi

B90012 X10
Ac 12.11.15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST	-30	
----	-----	--

WA	21	
----	----	--

66149	0	
-------	---	--

79336	1	
-------	---	--

88822	5	
-------	---	--

90011	15	
-------	----	--

WA013	30	
-------	----	--

D3067-1

End Plate

Manufactured

No

180

Each

226.0000

1

10

Ac 12.11.15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	222	
----	-----	--

78608	4	
-------	---	--

83855	1	
-------	---	--

90177	15	
-------	----	--

90178	22	
-------	----	--

90335	60	
-------	----	--

90336	60	
-------	----	--

90486	60	
-------	----	--

WA016	4	
-------	---	--

67582	2	
-------	---	--

68214	1	
-------	---	--

79607	1	
-------	---	--

AN3-35A

Bolt

5m3 10x

Purchased

No

250

Each

190.0000

2

20

SP12-11-21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	10	
----	----	--

122800	10	
--------	----	--

ST353	180	
-------	-----	--

123352	180	
--------	-----	--

Picklist Print

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Mounting Lug

SP 10x

Manufactured

No

250

Each

126.0000

2

20

SP



D3278-041

Support Assembly

AN960JD416

Washer

SP 10x

Manufactured

No

Location
ST470
90002

Loc Qty

126

126

Loc Code

20x
SP
16

20

160

m/23355

SP

AN960JD516

Washer

NAS1149D0563J

Purchased

No

Location
ST351
116289
119097

Loc Qty

29

8

21

Loc Code

40

m/23355

m/23355

ANS36A

Bolt

SP 10x

Purchased

No

Location
ST338
1069059

Loc Qty

2

2

Loc Code

20

m/23525

SP

D2618

Bushing

SP 10x

Manufactured

No

Location
ST338
123021

Loc Qty

46

46

Loc Code

2

20

SP

Picklist Print

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Page 5

Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No 250 Each 316.0000

Lug

SmD

10Y

Location	Loc Qty	Loc Code
FG	1	
89045	1	
ST469	315	
89782	19	
89950	200	
90514	96	

40 B89682 3X.

B92287 34X.



D2856-400

Abrasion Strip

Manufactured No 250 f 409.2539

SmA 10Y

Location	Loc Qty	Loc Code
ST403	120.2525	
81875	6.398	
89352	113.8545	
ST408	216	
90764	216	
ST409	73.0014	
63735	0.6696	
68076	0.3149	
71164	8.46	
86905	63.5569	

2X 12 SP 12-11-20



Picklist Print

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased No

250 Each 3,340.0000

20

Nut

Smbs 10Y

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
316	651	
122452	651	
ST300	338	
117885	32	
119017	168	
119075	138	
ST314	1831	
123265	1831	200X
ST317	520	
122141	520	

AN9-10A

Bolt

Smbs 10Y

Purchased No

250 Each 1,002.0000

8

80

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	809	
122416	287	
122808	22	
122993	500	
ST357	193	
120187	19	
120770	12	
121652	161	
122063	1	

12-11-20

SP

Picklist Print

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Work Order ID: 91959

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/19/12

Required Date: 11/09/12

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased No

250 Each 1,253.0000

20

20

Nut

Sm 10x

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
300	173	
121652	173	
314	1000	
122452	1000	
ST300	80	
108827	4	
116105	1	
116548	43	
119109	20	
2937	12	

MS21042L4

Purchased No

250 Each 5,326.0000

80

Nut

Sm 10x

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
314	1399	
122452	1399	
ST300	27	
119017	20	
121444	7	
ST314	3900	
123021	3000	
123248	900	

AN960JD10

NAS1149D0363J

Purchased No

250 Each 0.0000

40

Washer

Sm 10x

7/22378

SP 12-11-20.



DESIGN <i>QP</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04-*TH*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

GENERAL NOTES:

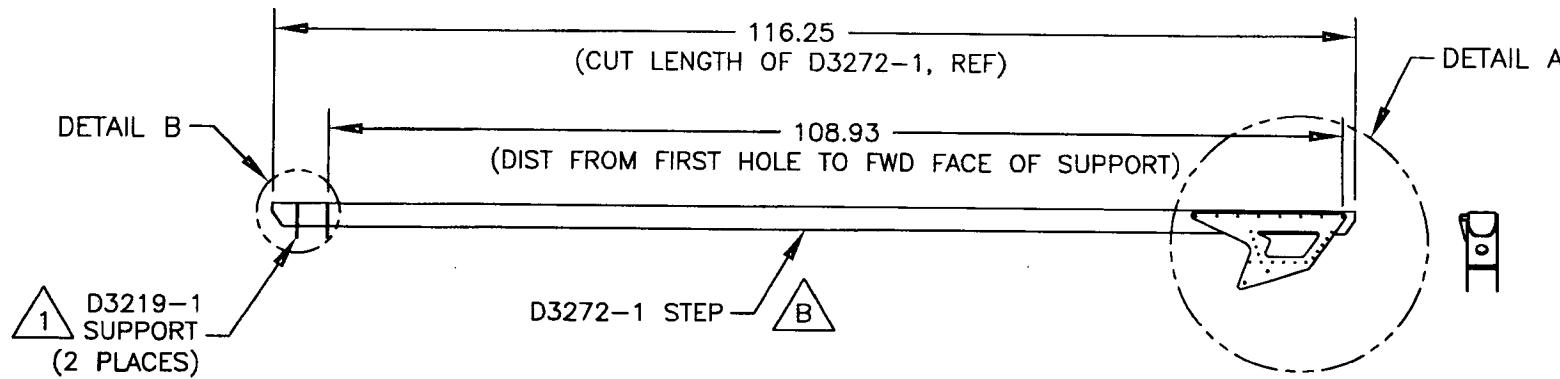
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

91959 MLC
 12-10-22
 WORKS
 INCONTINUOUS
 STANDARDS
 WITH
 ENCL. 1
 SHEET 1
 OF 3
 D3272

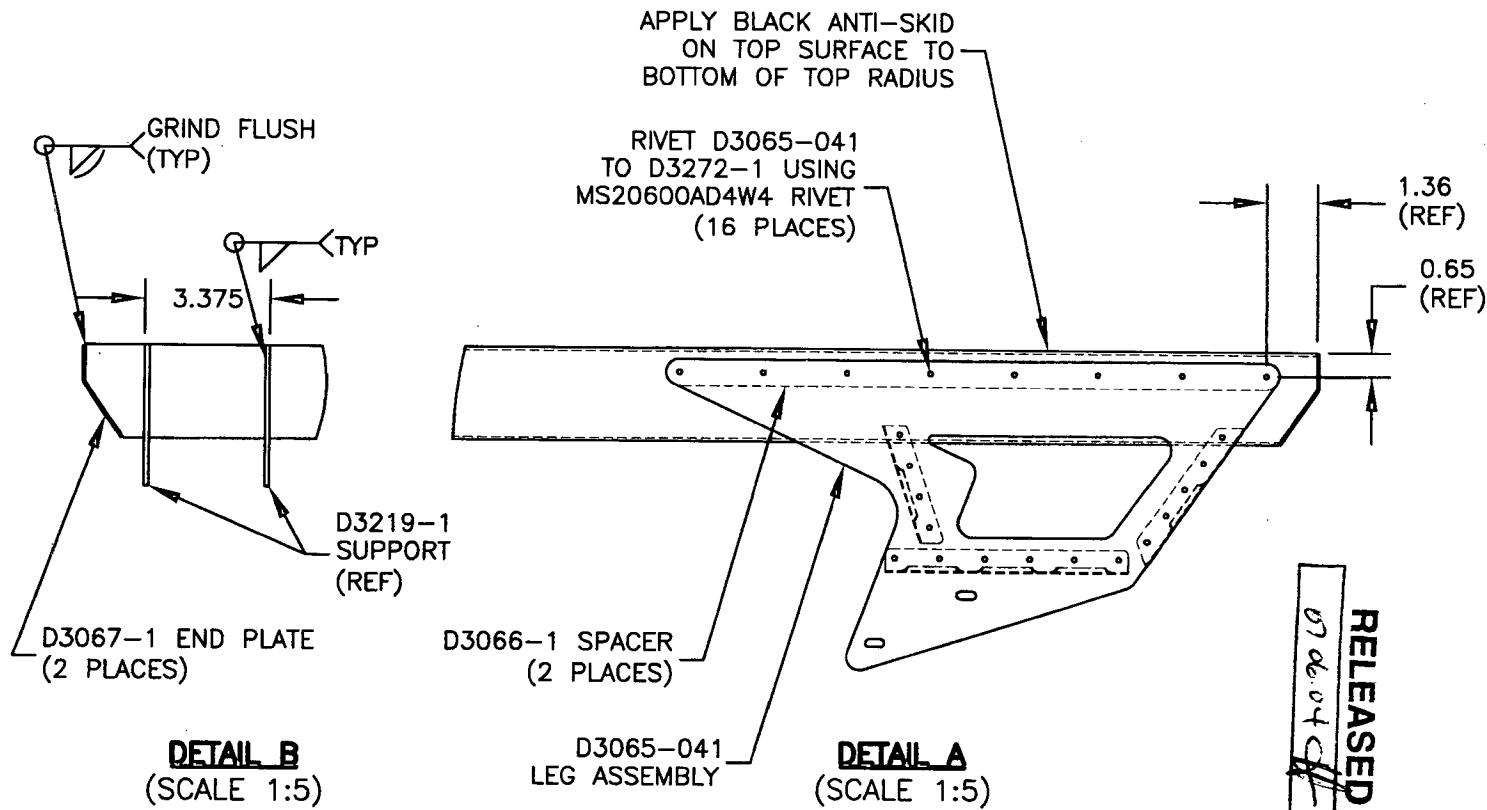
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91959



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

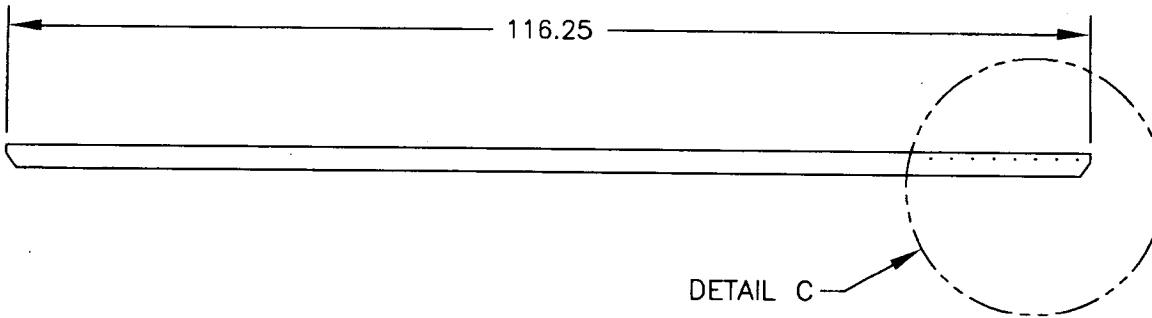


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DESIGN	90	DRAWN BY	J.B.	DART AEROSPACE LTD
CHECKED	CE	APPROVED	W.H.	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
TITLE	STEP ASSEMBLY, LH LONG	SHEET	2 OF 3	1:20
SCALE				

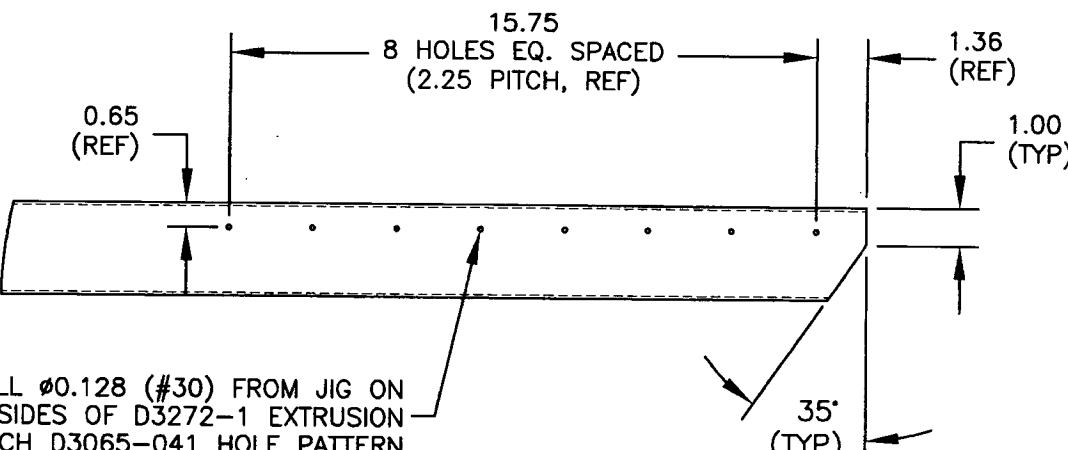
91959

DART

B

D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

07/06/04
RELEASED

DESIGN	DRAWN BY	DART AEROSPACE LTD
checked	APPROVED	HAWKESBURY, ONTARIO, CANADA
<i>le</i>	<i>jk</i>	DRAWING NO.
DATE	07.05.18	D3272
DATE		TITLE
		STEP ASSEMBLY, HI LONG
		SHEET 3 OF 3
		SCALE
		1:20